

Work Order ID 124393***124393***

Page 1

September-17-14 1:30:17 PM

Item ID: D2432

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Bearpaw 19" X 24"

Start Date: 9/10/14 Start Qty: 8.00 ***g***

Cust Item ID:

Required Date: 9/10/14 Req'd Qty: 8.00 ***g***

Customer:

Reference:

Approvals:

Process Plan: 

Date: _____

Tooling: _____

Date: _____

Run Start ***NR1***

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D2432

H

105

0.00

105

Purchasing

Memo

0.00

Purchasing

ISSUE PO 25836
cut blanks per D2432 fileCD 14/10/18 8

110

Receive & Inspect for Damage & Mat'l Certs

0.00

110

Packaging

Memo

0.00

Packaging

12/4/14/11 8

125

QC6- Inspect dimensions to drawing

0.00

125

QC

Memo

0.00

Quality Control

amk 14/10/26 8 8

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September-17-14 1:30:17 PM

Item ID: D2432 Accept ***N900040100*** Setup Start ***NS1***
Revision ID: Stop ***NS2***
Item Name: Bearpaw 19" X 24"
Start Date: 9/10/14 Start Qty: 8.00 ***g*** Cust Item ID:
Required Date: 9/10/14 Req'd Qty: 8.00 ***g*** Customer:
Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* HAAS 1 HAAS CNC vertical machine #1	HAAS CNC VERTICAL MACHINING #1 Memo 1-Inspect material for defects or damage prior to machining 2-Machine as per Folio and Dwg D2432 Identify as D2432F 3-Deburr	0.00 0.00				8			
140 *140* QC Quality Control	QC2- Inspect parts off machine FAI/FAIB Memo	0.00 0.00				6			
150 *150* QC Quality Control	QC8- Inspect parts - second check Memo	0.00 0.00				8			SL14-10-28

Work Order ID 124393

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124393

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Item ID: D2432

Accept

N19000040100

Setup Start

NS1

Revision ID:

Stop

NS2

Item Name: Bearpaw 19" X 24"

Start Date: 9/10/14

Start Qty: 8.00

g

Cust Item ID:

Required Date: 9/10/14

Req'd Qty: 8.00

g

Customer:

Reference:

Approvals:

Process Plan: _____

Date: _____

Tooling: _____

Date: _____

Run Start

NR1

QC: _____

Date: _____

SPC (Y/N): _____

Date: _____

Stop

NR2Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

Identify as per dwg & Stock Location: _____

0.00

160

Packaging

Memo

0.00

Packaging

PP 121827

8

DAS

03

9-09

OCT 31 2014

170

QC21- Final Inspection - Work Order Release

0.00

170

QC

Memo

0.00

Quality Control

14/11/3

14-11-03

Picklist Print

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Page 1

Work Order ID: 124393

124393

Parent Item: D2432

D2432

Parent Item Name: Bearpaw 19" X 24"

Start Date: 9/10/14

Required Date: 9/10/14

Start Qty: 8.00

Required Qty: 8.00

Comments: IPP REV:A 12.10.17 AS PER DWG REV.H DD VERF:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
MUHMWB10		Purchased	No			120	sf	371.4000	3.7	30			

MUHMWB10

UHMW 1" Black - 48"x120" Tivar Mfg.#52480104

**

CX(4)10/03

Location

Loc Qty

Loc Code

MAT014

371.4

m128267

47

m128668

297.3

m129293

27.1

m130421

x30

DART AEROSPACE LTD		Work Order: 124393
Description: Bearpaw		Part Number: D2432
Inspection Dwg: D2432	Rev: H	Page 1 of 1

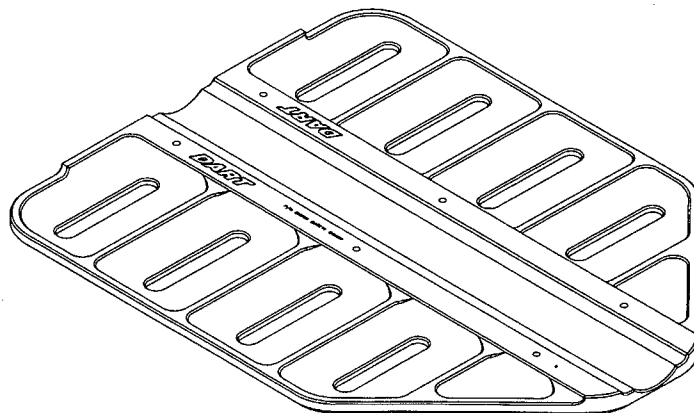
FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
0.063 x 45°	+0.030/-0.010	.063	/		CNC-D2	vern
5.500	+/-0.030	5.500	/			
0.200	+/-0.030	.193	/			
0.25 x 45°	+/-0.030	.213	/			
R0.250	+/-0.030	.25	/			
0.250	+/-0.010	.252	/			
0.625	+/-0.030	.630	/			
0.380	+0.030/-0.010	.385	/			
0.950	+0.030/0.010	.955	/			
19.000	+/-0.030	19.00	/			
3.14	+/-0.030	3.14	/			
3.28	+/-0.030	3.28	/			
Ø0.260	+0.005/-0.000	.260	/			
Ø0.93	+/-0.030	.930	/			
0.30	+0.030/-0.000	.305	/			
23.750	+/-0.030	23.750	/			
4.250	+/-0.010	4.250	/			
2.000	+/-0.030	2.015	/			
9.000	+/-0.010	9.00	/			
9.000	+/-0.010	9.00	/			
0.375	+/-0.030	.382	/			

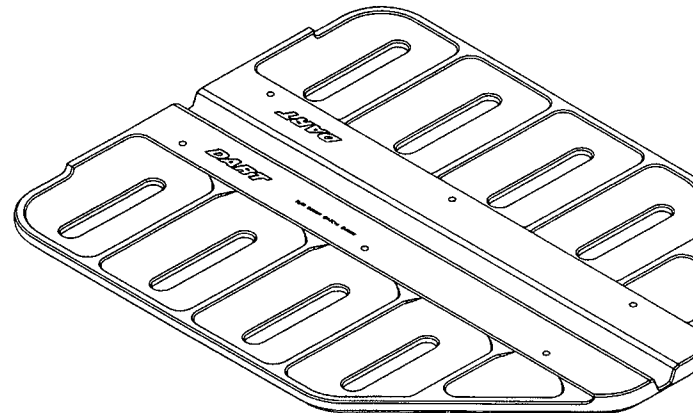
Measured by: [Signature]	Audited by: [Signature]	Preliminary Approval:
Date: 14/10/26	Date: 14/10/28	Date:

Rev	Date	Change	Revised by	Approved
A	04.01.09	New Issue P/O D206-559-015	KJ/RF	
B	12.07.31	Dwg Rev updated	KJ	
C	12.10.26	Dwg Rev updated	KJ	
D	13.07.18	Dimension 7.375 removed	KJ	[Signature]

SHOP COPY
 RETURN TO
 ENGINEERING
 UNCONTROLLED COPY
 SUBJECT TO AMENDMENT
 WITHOUT NOTICE
 WORK ORDER
 NO. 124393 MLJ
 14-09-17



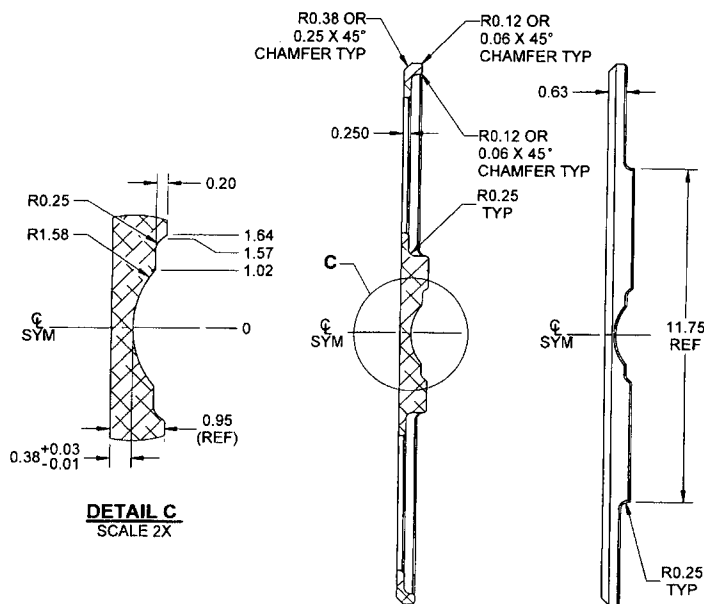
D2432F BEARPAW



D2432-3 BEARPAW

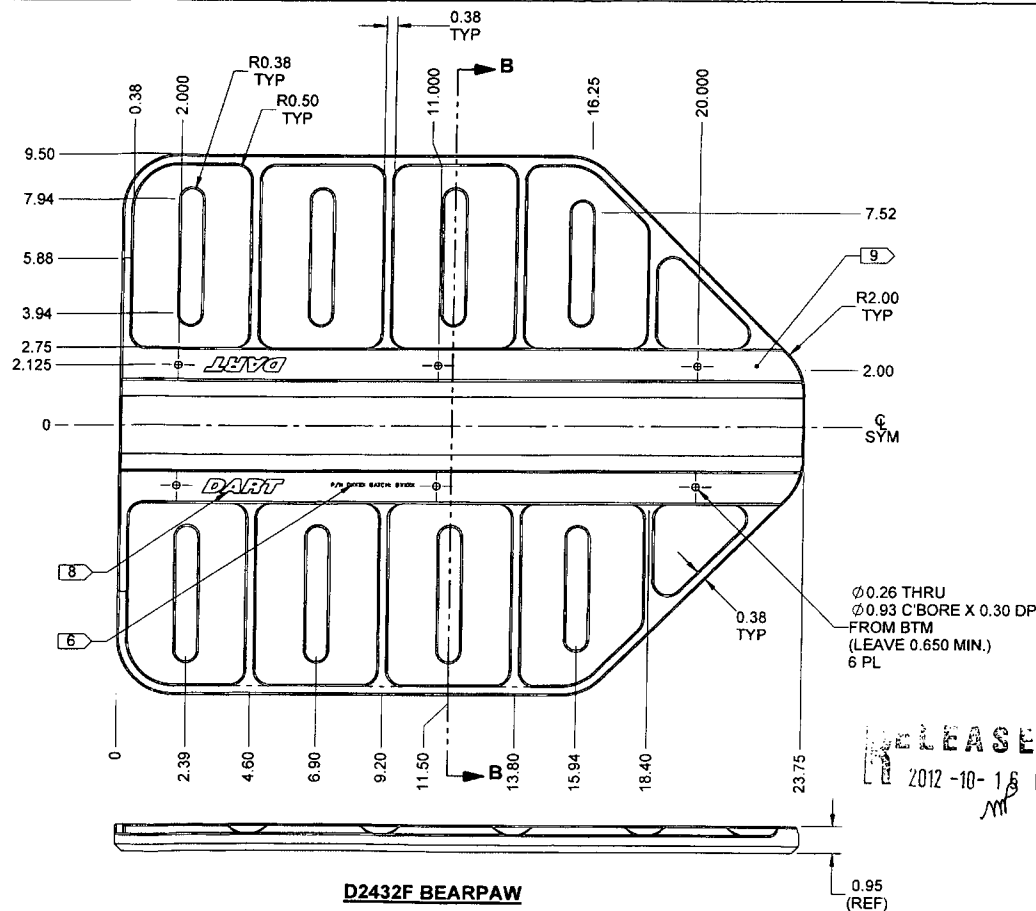
RELEASED
 2012-10-16

H	RIB HEIGHTS CHANGED TO CONDITION OF REV. F. SEE REV. F FOR DETAILS.	AP	12.09.24
G	UPDATE DRAWING FORMAT, REMOVED D2432B, ADD D2432-3, ADDED DIMENSION 7.52 (D1-2)	AP	12.05.02
F	CHANGE C'BORE, ADD B AND F P/N	-	98.05.12
E	CHANGE C'BORE DEPTH, BORE RADIUS	-	97.02.27
D	MOVE SLOT	-	96.06.04
C	CHANGE BORE AND C'BORE DEPTH	-	96.03.26
B	RE-DESIGN	-	96.01.24
A	NEW ISSUE	-	95.10.31
REV.	DESCRIPTION	BY	DATE
DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	<u>ALS</u>	DRAWING NO.	REV. H
MFG. APPR.	<u>at</u>	D2432	SHEET 1 OF 3
APPROVED	<u>10</u>	TITLE	SCALE
DE APPR.	<u>14</u>	BEARPAW	NTS
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SECTION B-B

DETAIL C
SCALE 2X



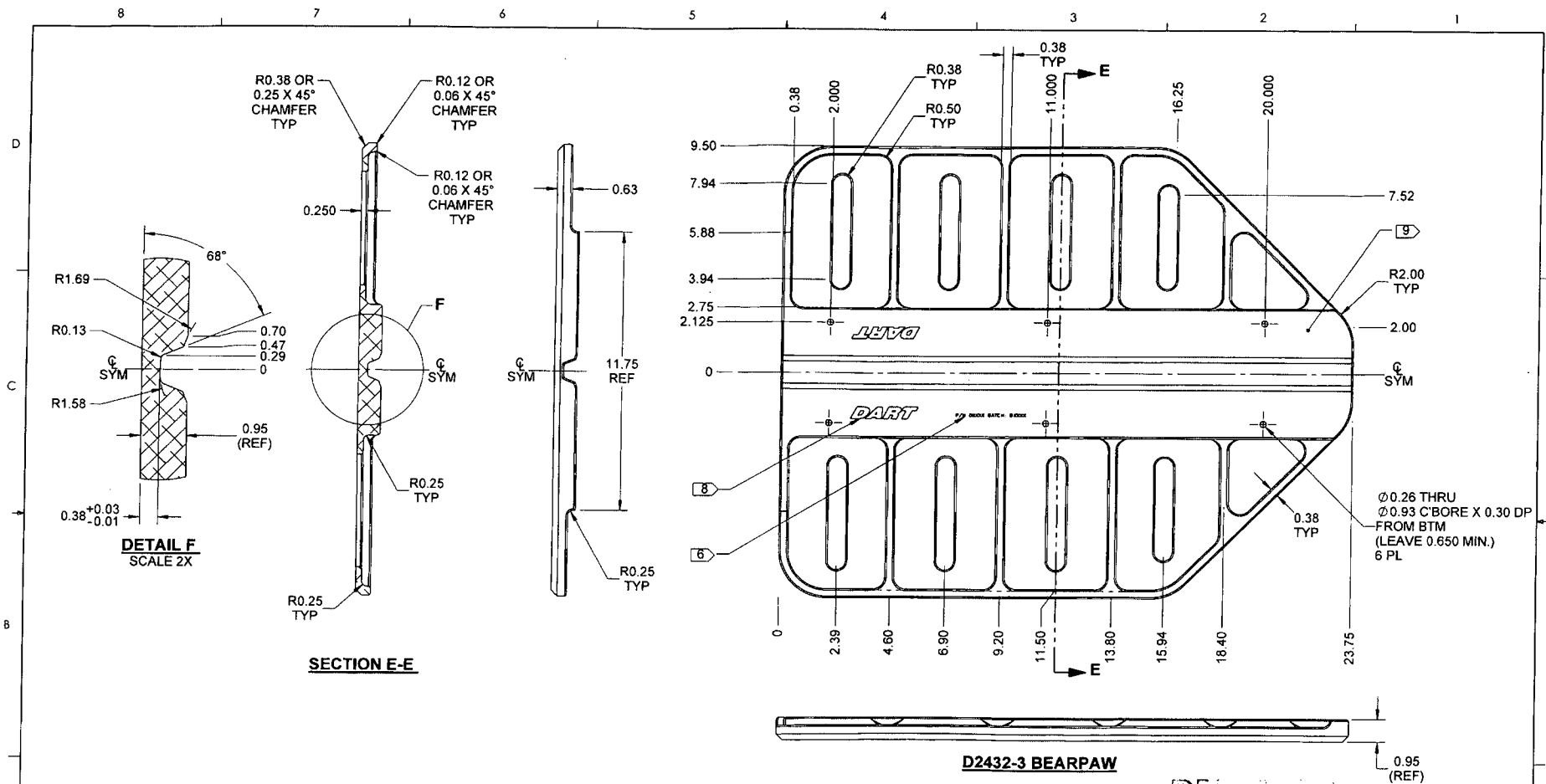
D2432F BEARPAW

NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMBW10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 5.87 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2434F-REVH.STP"

DESIGN	LE	DART AEROSPACE LTD	
DRAWN	AP	HAWKESBURY, ONTARIO, CANADA	
CHECKED	ASS	DRAWING NO.	REV. H
MFG APPR.	AT	D2432	SHEET 2 OF 3
APPROVED	AP	TITLE	SCALE
DE APPR.	AP	BEARPAW	NTS
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2012-10-16



NOTES:

- 1) MATERIAL: UHMW BLACK TIVAR 1000 VIRGIN MATERIAL, 1.000 THICK MACHINED TO 0.950 (REF DART SPEC. MUHMBW10)
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: ENGRAVE PART NUMBER "D2432-3" AND BATCH NUMBER "BXXXXX" IN ACCORDANCE WITH QSI 044 METHOD 6.3
- 7) WEIGHT: 6.25 lbs
- 8) ENGRAVE DART LOGO TO MAX DEPTH OF 0.012
- 9) APPLY 0.06 x 45° CHAMFER TO ALL EDGES ON SIDE SHOWN UNLESS OTHERWISE INDICATED
- 10) PROFILE PER DRAWING FILE "D2432-3-REVH.STP"

D2432-3 BEARPAW

RELEASED
2012-10-16

DESIGN	LE	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO. D2432	REV. H
MFG. APPR.	gt		SHEET 3 OF 3
APPROVED	140	TITLE BEARPAW	SCALE
DE APPR.	140		NTS
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T.P.I. INDUSTRIES INC.

148 GOODFELLOW
DELSON, QUÉBEC J5B 1V4
CANADA
Tel: (450) 633-0484
Fax: (450) 633-0879

Packing Slip

Packing Slip No.: 6316
Date: 2014-09-29
Page: 1

Sold to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada	Ship to: Dart Aerospace Michael Grégoire 1270 Aberdeen Hawkesbury, Ontario K6A 1K7 Canada
Order No.: 100810	Sold By: JONATHAN LESSARD
Shipped By:	Ship Date: 2014-09-29
Tracking No.:	

Item No.	Unit	Description	Quantity
d2432-3	Chaque	d2432-3 bearpaw	2
d2435	Chaque	d2435 bearpaw	18
d2521	Chaque	d2521 bearpaw	22
d2432	Chaque	d2432 bearpaw	15
d4930-1	Chaque	d4930-1 bearpaw	8
d4355-1	Chaque	d4355-1 bearpaw	7
d4353-041	Chaque	d4353-041 bearpaw	2
d4297-1	Chaque	d4297-1 bearpaw	2
d2995	Chaque	d2995 bearpaw	2

Comment: Des frais d'intérêts de 2% / mois seront chargés sur tout compte passé du après 30 jours